

Date: Monday, 5/1/2006 4:22:42 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: OUTLET WELDMENT (206)	
Job Number	: 26906		Part Number	: D2414	
Estimate Number	: 10473		Drawing Number	: D2414 REV. A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/1/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/30/2006	
Previous Run	: N/A		Qty:	3	
Written By	: <u>See JF COMMENT BELOW</u>		Um:	Each	
Checked & Approved By	: <u>JF 06.05.02</u>				
Comment	: Est: C 03.04.14 Rerformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2292	Heater Tube 4"	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Heater Tube 4"	
		Qty Part Number Description Batch	<u>B21844</u> ③
		1 D2292 4" Ring	
2.0	D2406	3" Heater Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		3" Heater Tube	
		Qty Part Number Description Batch	<u>B17130</u> ①
		1 D2406 3" Tubing	
3.0	D2415	End Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		End Plate	
		Qty Part Number Description Batch	<u>B24398</u> ②
		1 D2415 End Plate	
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		Weld D2414 Outlet Assembly as per Dwg D2414 and QSI 004.	
			<u>M 06/05/16</u> ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/06/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

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Drawing Name: OUTLET WELDMENT (206)

Job Number: 26906

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 06-05-16

(3)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DC 06/05/23

(3)

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

PPC 06/05/24

(3)

8.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 1342

CL06/05/24

(3)

Red Anodize D2414 as per Dwg D2414

Possible Supplier: Anodizing TNM Paint

Ensure Certificate of Conformity is attached

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

PPC 06/05/25

(3)

Ensure certificate of conformity is attached

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

CL06/06/06

(3)

Location: ST171

12.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

CL06/06/07

(3)

Inspection Level 21

CL06/06/07

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PREPARED B. Williams	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995	D2414 TITLE 206 OUTLET WELDMENT	

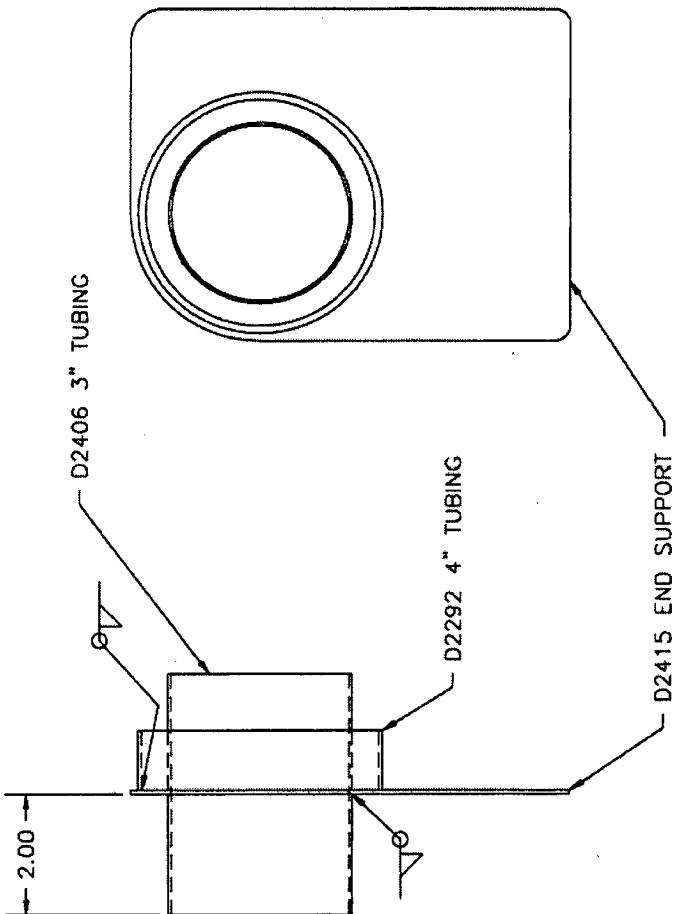
RELEASED  
4/6/95/10 BW

QTY	Part No.	Description
X	D2414	OUTLET WELDMENT ASSEMBLY
1	D2292	4" TUBING
1	D2406	3" TUBING
1	D2415	END PLATE

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26906

**DART**

PREPARED		DART AERO ACCESSORIES INC	
B. Williams		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	REV. A	
BW	BW	D2414	
DATE		SHEET 2 OF 2	
Apr. 6, 1995		TITLE	
		SCALE	
		206 OUTLET WELDMENT	

**RELEASED**  
96/09/10 BW

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WORK ORDER  
NO. 26906





21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2  
 Telephone: (514) 429-7777 Fax: (514) 429-5108  
 Certifié ISO 9001-2000 / AS9100 certified  
 approuvé NADCAP approved

48039

02-Jun-2006

## CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET  
 HAWKESBURY, ONTARIO  
 K6A 1K7

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE

PURCHASE ORDER/  
NO. DE COMMANDE: 00001342



ITEM	COMMANDÉ ORDERED	EXPÉDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	2	2	D2413 B25019	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	3	3	D2414 B26906	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	2	2	D2413 & D2414 B24398	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
 Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.  
 Travel cards have been filed and are available for viewing upon request.

Signature/Signed:

 Directeur de la Qualité / Q.A. Manager
